

Date: Friday, 9/21/2007 1:18:29 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	: 34812		Part Number	: D2571		
Estimate Number	: 10530		Drawing Number	: D2571 REV E		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 9/21/2007		Type	: MACHINED PARTS		
Prsht Rev.	: NC		Drawing Revision	: E		
First Issue	: 9/21/2007		Material	: N/A		
Previous Run	: 34748		Due Date	: 10/18/2007		
Written By	: J.A.		Qty:	8	Um:	Each
Checked & Approved By	: J.A. 07/09/04					
Comment	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101007	7075-T7351 8.25X7.75X2.5 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2571 Ensure that grain is along 7.75" length Batch No: <u>531389</u> JL 07/10/25		
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1 
Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>84</u> Double check by: <u>J.F.</u> 1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges. JL 07/10/25		
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE 
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572 JL 07/10/28		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE JL 07/10/28		

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/01/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/21/2007 1:18:29 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 34812

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

DK 07/10/28 (8)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/10/29 (8)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 07/10/29 (8)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/10/30

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

(8) 07/10/30 AB C

10.0 QC21 FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/10/30

Job Completion



U 07-10-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	34812
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	.440	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.001		
F	0.490	0.510		.500	.498	.500	.502		
G	0.257	0.262	DT8683	.258	.258	.258	.257		
H	0.375	0.380	DT8684	.376	.375	.375	.375		
I	0.490	0.510		.502	.503	.500	.504		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.564	.570	.570	.567		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.126	.123	.123	.123		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.252	.252	.253	.251		
S	0.115	0.135		.130	.130	.130	.124		
T	0.178	0.198		.184	.184	.188	.188		
U	2.940	2.980		2.962	2.961	2.962	2.962		
V	0.230	0.250		.240	.240	.245	.242		
W	0.115	0.135		.121	.123	.123	.116		
X	0.308	0.313		.313	.313	.312	.311		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.365	.365	.365	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.628	.625	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.252		
AE	1.375	1.395		1.382	1.391	1.390	1.381		
AF	0.115	0.135		.125	.125	.125	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.258		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	J.S.	/	J.L.	Audited by:	QNL
Date:	07/10/25	/	07/10/28	Date:	07/10/28

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM

DART AEROSPACE LTD				Work Order:	34812
Description: Saddle, Fwd Outboard				Part Number:	D2571
Inspection Dwg: D2571 Rev. E				Page 1 of 1	

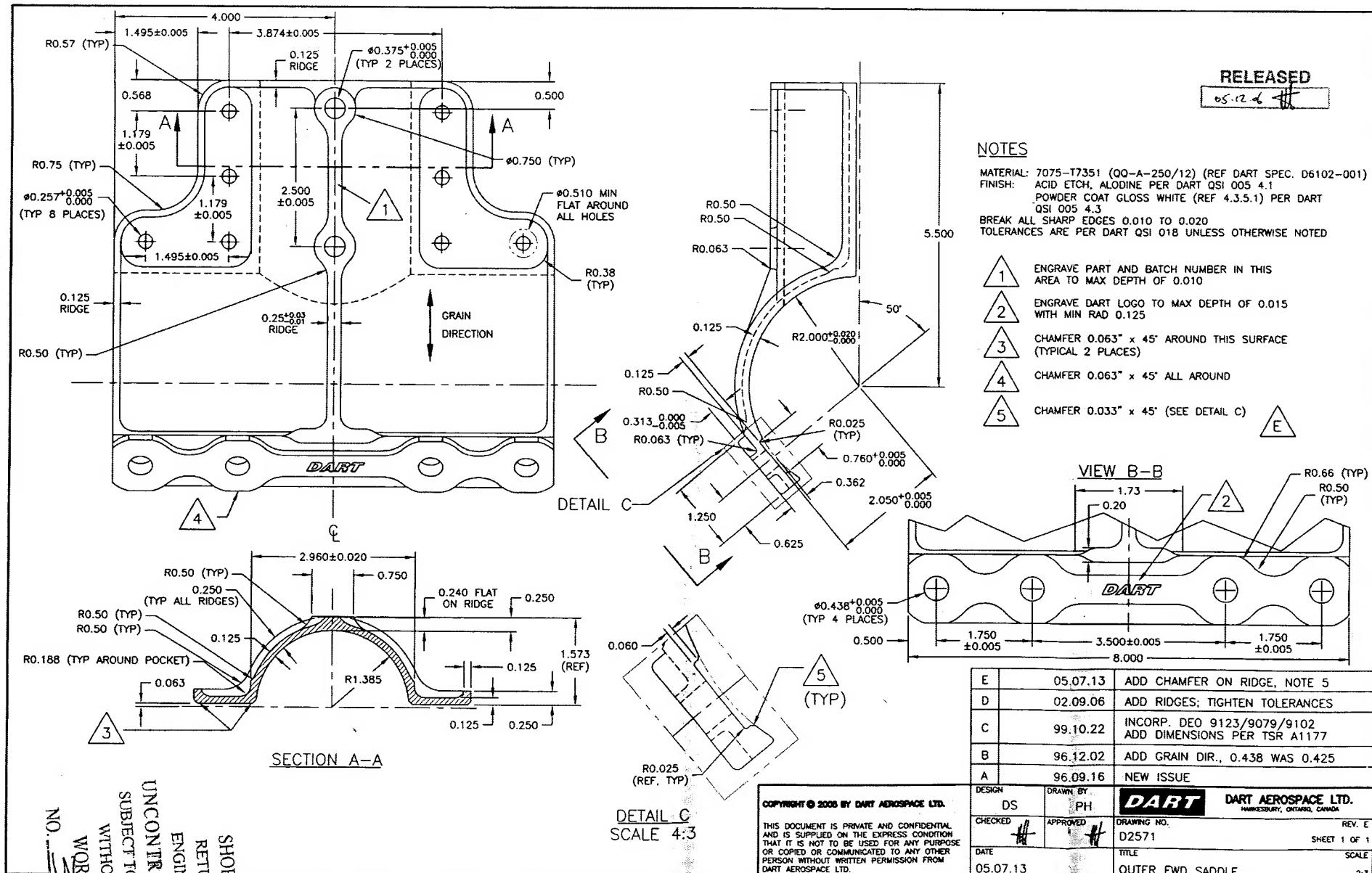
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D	1.745	1.755		1.750	1.750	1.750	1.750		
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F	0.490	0.510		.498	.501	.502	.502		
G	0.257	0.262	DT8683	.257	.257	.257	.257		
H	0.375	0.380	-DT8684	.375	.375	.375	.375		
I	0.490	0.510		.501	.502	.502	.504		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.568	.567		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.500	1.500	1.500		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.122	.120	.123	.122		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.249	.250	.250		
S	0.115	0.135		.125	.123	.125	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.962	2.962		
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W	0.115	0.135		.117	.117	.116	.120		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.763	.763	.763	.763		
Z	0.352	0.372		.365	.365	.367	.368		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.627	.626	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.253	.255	.250	.248		
AE	1.375	1.395		1.381	1.380	1.384	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.257	.259	.256	.253		
AI	2.000	2.020		2.000	2.000	2.000	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	<i>JL</i>	/	3-L	Audited by:	<i>CMC</i>
Date:	<i>07/10/28</i>	/	07/10/28	Date:	<i>07/10/28</i>

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E	05.12.05	Added dimension AJ	KJ/JLM	<i>JL</i> <i>JLM</i>



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